

Date: Monday, 18/08/2008 3:46:47 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SHORT T-HANDLE ASSY
Job Number	: 41384		
Estimate Number	: 13529		
P.O. Number	:	Part Number	: PB674300163
This Issue	: 18/08/2008 S.O. No. :	Drawing Number	: B6743001 P.15
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: B1
Previous Run	: 40816	Material	:
Written By	:	Due Date	: 18/09/2008 Qty: <u>4</u> Um: Each
Checked & Approved By	: <u>JLD 08.8.18</u>		
Comment	: Est Rev:A 08-07-29 new issue DD verified by:ec		

Additional Product PB6743001-137 → B40023 → 4QTY

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB6743001131	Tube End Cap
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)
 Tube End Cap
 batch: B41480

08.09.30 4

2.0	PB6743001129	Tube Handle
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
 Tube Handle
 batch: B40019

08.09.30 4

3.0	PB6743001127	Handle Arm
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
 Handle Arm
 batch: B40018

5 stoc

08.09.30 4

4.0	PB6743001157	Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
 Tube
 batch: B40026

08.09.30 4

5.0	CR321342	Cherry Rivet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
 Cherry Rivet
 batch: M102569

08.09.30 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 3:46:47 PM
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Process Sheet

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Drawing Name: SHORT T-HANDLE ASSY

Job Number: 41384

Part Number: PB674300163

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- 1- chamfer both ends (0.090") on -129 and -127
- 2- chamfer (0.090") only the angle end on -157
- 3- drill #40 hole in center of -129 before welding -131 caps, to let air out
- 4- weld -131 to -129 as per dwg
- 5- grind weld flush
- 6- assemble -127 under the pilot hole in -129 and -157 weld as per dwg
- 7- grind weld flush
- 8-i nstall rivet as per dwg

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

****mask only -157 starting from rivet to end of -157 tube, rivet must be powder coat****
Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:15
320°F
3:45

M-L 08/10/03

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0

240107

SPRING SLOTTED PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

SPRING SLOTTED PIN

batch:

17850 x4

STE 08/10/06 (x4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: SHORT T-HANDLE ASSY

Job Number: 41384

Part Number: PB674300163

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PB6743001133

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Clevis

batch: 23994B x4

SS 08/10/08 (x4)

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble by drilling thru both -157 and -133 as per dwg

2- install spring slotted pin as per dwg

Pl 08.10.22 (x4)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/23 (x4)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 508/10/23

Shore (x2) Carl welding 508/10/23 (x4)

16.0

QC21

FINAL INSPECTION W/O RELEASE



Comment: FINAL INSPECTION W/O RELEASE

08/10/23 (x4)

Job Completion



MF 08-10-23

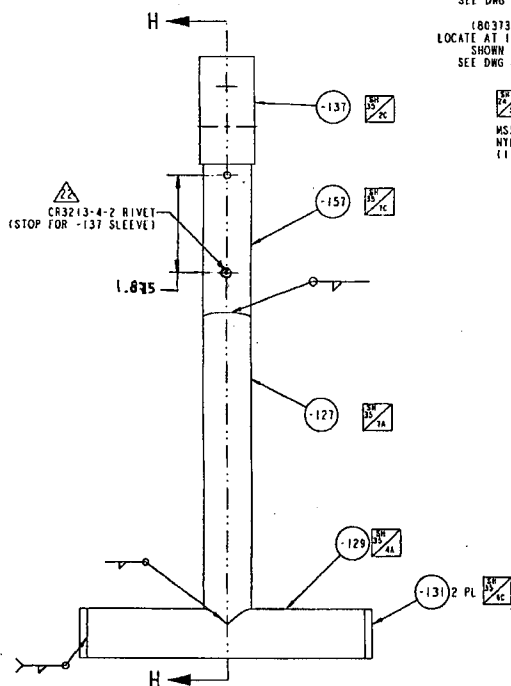
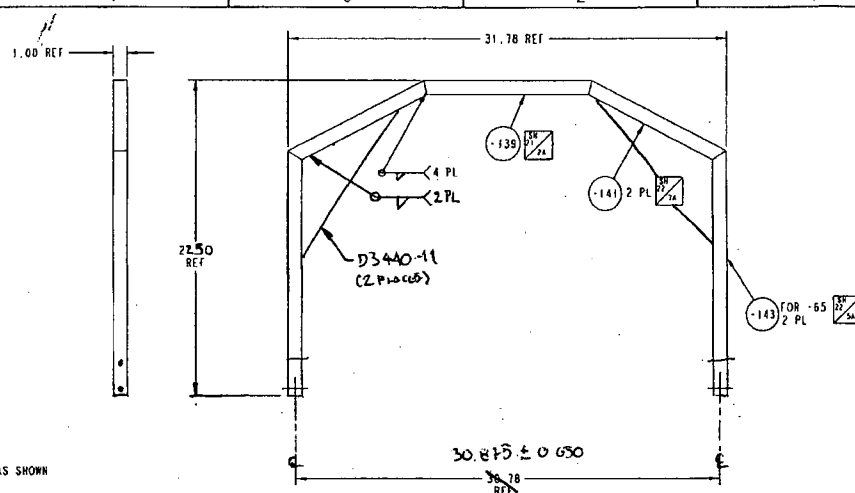
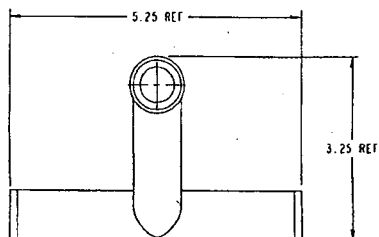
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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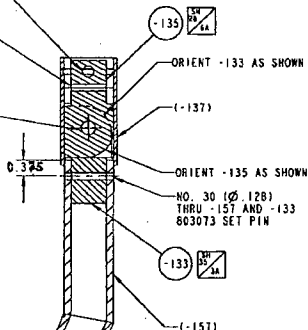
NOTE: Date & initial all entries



(CL-40-SBP-3 DETENT) REF
LOCATE AT INSTALLATION,
SHOWN HERE FOR REF
SEE DWG SH3 AND SH4)

(80373 SET PIN) REF
LOCATE AT INSTALLATION,
SHOWN HERE FOR REF
SEE DWG SH3 AND SH4)

MS51059-6
NYLON WASHER (2)
11 EA SIDE -135)

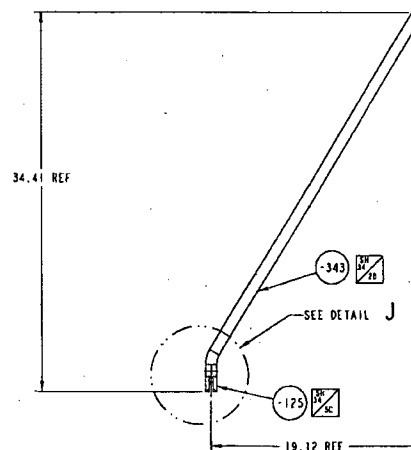


SECTION H-H

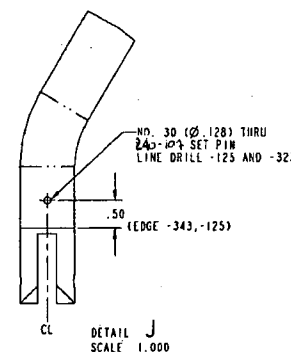
RELEASED
06 of 20

~~68~~ BASE ASSEMBLY (SHOWN)
(COMMERCIAL VERSION)
SCALE 0.250

~~47~~ BASE ASSEMBLY (SAME, EXCEPT AS SHOWN)
(CANADIAN VERSION)



① -37 TUBE ARM ASSEMBLY
SCALE 0.200



DETAIL J
SCALE 1.000

PREMIER AVIATION, INC.
2000 Aviation Parkway, Grand Prairie, Texas 75052

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ORIGINAL

WORK ORDER
NO. 41384

WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
68 SHORT T-HANDLE ASSEMBLY
SCALE 1.000